

Work Order ID 83867

83867

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April-26-12 2:29:15 PM

Item ID: D3413-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Ring
 Start Date: 26/04/2012 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 10/05/2012 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/26 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3413	Rev A

100

100

Waterjet

FLOW CNC Waterjet

304 .250 x .4.00"

FLOW WATER JET

Memo

1-Cut as per Dwg D3413

Dwg Rev: A

Prog Rev: A

2- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

0.00

0.00

20 0

Jm/whl
12-5-8

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

20 0

Jm/whl
12-5-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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120 QC8- Inspect parts - second check 0.00

120

QC

Quality Control

Memo

0.00

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat

Powder Coating

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

M121134

4000F

8:45

9:15

count
720

20X

MAF
12/05/09

20

BP1259

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Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 26/04/2012 **Start Qty:** 20.00

20

Cust Item ID:

Required Date: 10/05/2012 **Req'd Qty:** 20.00

20

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

170

Identify as per dwg & Stock Location:

0.00

170

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

20x

~~80~~
125-9

12/5/10 JJ

MLJ 12/05/09

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Picklist Print

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Work Order ID: 83867

83867

Parent Item: D3413-1

D3413-1

Parent Item Name: Ring

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP Rev:A05.09.13New issueKJ/JLM

IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	43.0000	0.25	5.263158			

M304B0 250X4 000

304 BAR .250 x 4.00

Location

Loc Qty

Loc Code

MA050

43

119043

17

119766

14

119840

12

119766

15.3

Jm/ah
12-5-8

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Dart Aerospace Ltd

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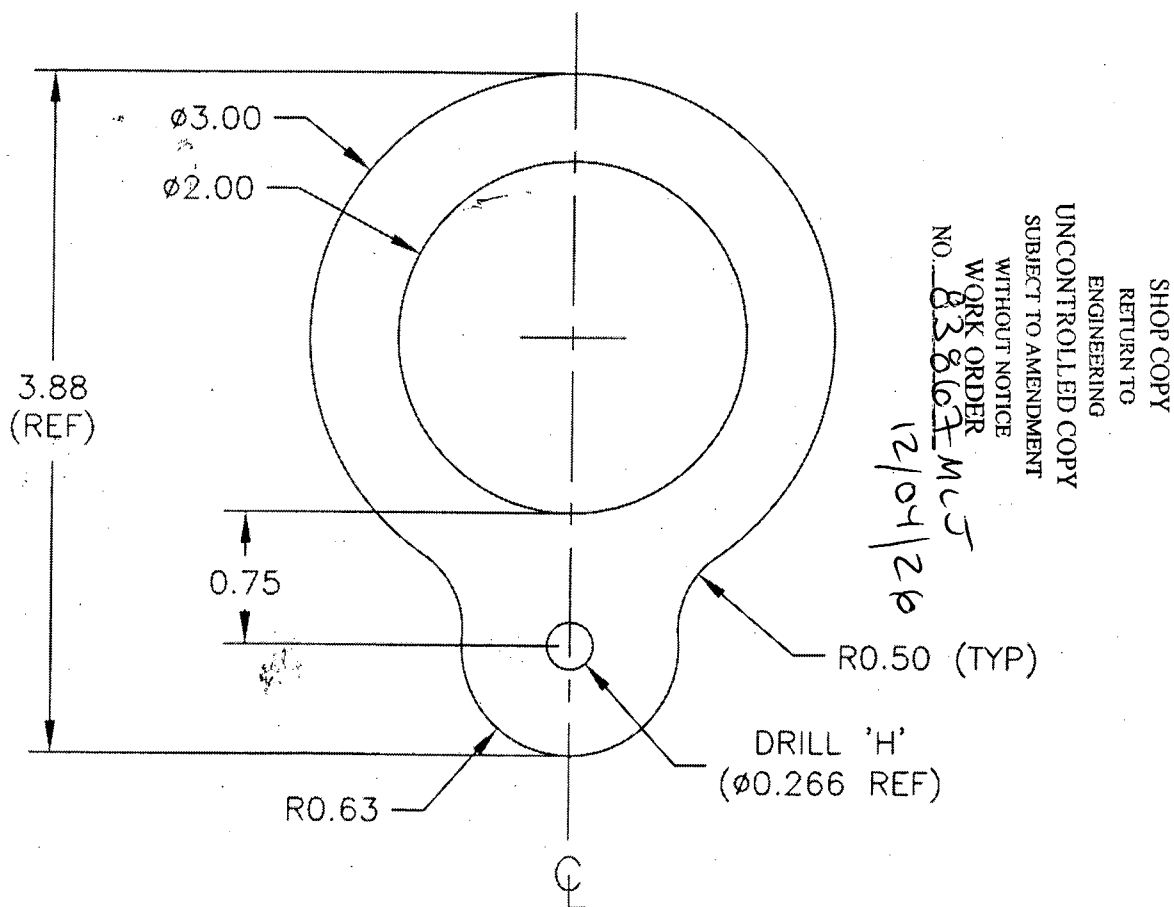
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

RELEASED
05-09-06 *[Signature]*



D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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